

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011395**Date Inspected:** 16-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Fawen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG) Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY 2**

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 005065

**Magnetic Particle Testing (MT)**

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. LD3022 – 001 – 036; 044; 056; 064; 072; 077; 085

This QA Inspector observed the following work in progress:

**Flux Core Arc Welding (FCAW):**

Weld joint # 005 located on Traveler Rail 20TR1 – 009. Welder is identified as 058245. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

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Weld joint # 007 located on Traveler Rail 20TR1 – 016. Welder is identified as 048696. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 005 located on Traveler Rail 20TR1 – 014. Welder is identified as 062708. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 007 located on Traveler Rail 20TR1 – 015. Welder is identified as 045227. ZPMC Quality Control (QC) Inspector is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

### BAY 5

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 007 located on Traveler Rail 11TR1 – 015. Welder is identified as 217185. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Repair welding of a weld joint # 014 located on Traveler Rail 10TR3 – 001. Welder is identified as 204342. ZPMC Quality Control (QC) Inspector is identified as Shen Jian Guo. The welding variables recorded by QC appeared to comply with the WPS: WPS – 345 – FCAW – 2G (2F) – Repair – 1 according to the welding repair report: B-WR9214 (see attached photos).

### BAY 7

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 007 located on Traveler Rail 22TR2 – 002. Welder is identified as 066471. ZPMC Quality Control (QC) Inspector is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint #005 located on Traveler Rail 22TR2 – 002. Welder is identified as 068859. ZPMC Quality Control (QC) Inspector is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Weld joint # 001 located on Traveler Rail 22TR4 – 003. Welder is identified as 066695. ZPMC Quality Control (QC) Inspector is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U5 – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

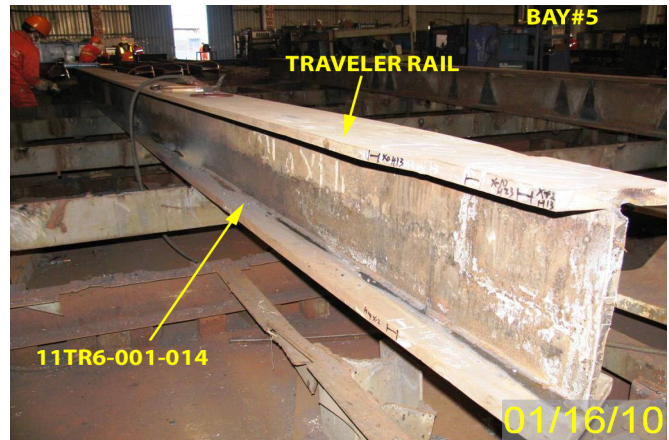
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# WELDING INSPECTION REPORT

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documents.



## Summary of Conversations:

No Relevant Conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven
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QA Reviewer
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